

Date: Monday, 8/21/2006 2:10:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Job Number : 28246	
Estimate Number : 10258	
P.O. Number : N/A	Part Number : D2332041
This Issue : 8/21/2006 S.O. No. : N/A	Drawing Number : D2332 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : C1
Previous Run : 27690	Material : N/A
Written By : <u>JA 06/08/21</u>	Due Date : 9/20/2006
Checked & Approved By : <u>JA 06/08/21</u>	Qty: 20 Um: Each
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

M19448

MF - 06/08/30

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)
 Material: Ø0.250" 304SS Rod
 Batch M17931

MF. 06/08/29

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

MF. 06/08/31 (20)

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

MF. 06/08/29 (20)

3-Deburr

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)
 304 RD Tube .500 x .035W

MW1593

MF. 06/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: . _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 06/09/01 (20)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)
2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

mf. 06/08/01 (20)

A/R SS Rod Batch: M100372

06/09/07 (20)

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-09-07 (20)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

mf. 06/09/08 (20)

2-Assemble as per Dwg D2332

mf. 06/09/19 (20)

9.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description
1 AN4-4A Bolt

Batch
m100831

mf. 06/09/19

10.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description
3 AN960JD416L Washer

Batch
m101231

mf. 06/09/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description
1 MS21042L4 Nut (or -4)

Batch

MI 9085

mf - 06/09/19

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EB 06/09/19

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/69

EB

06/09/20

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

EB 06/09/20

Job Completion



U 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

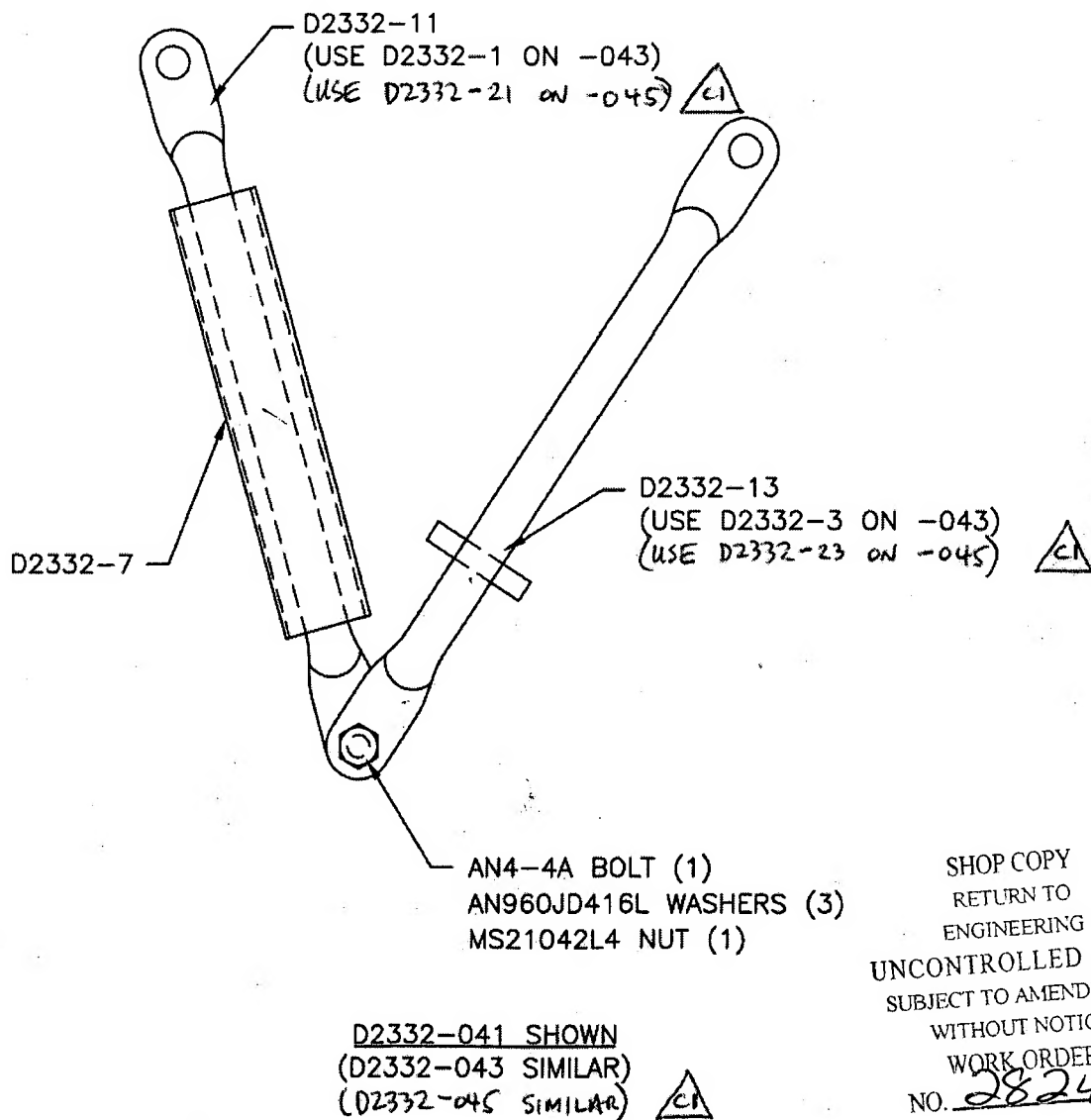
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 

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WORK ORDER
NO. 28246

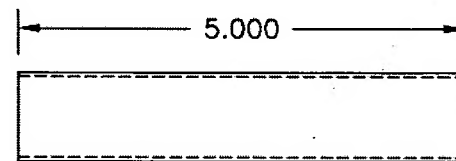
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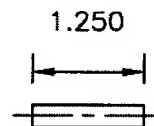
DART

ISSUED TO

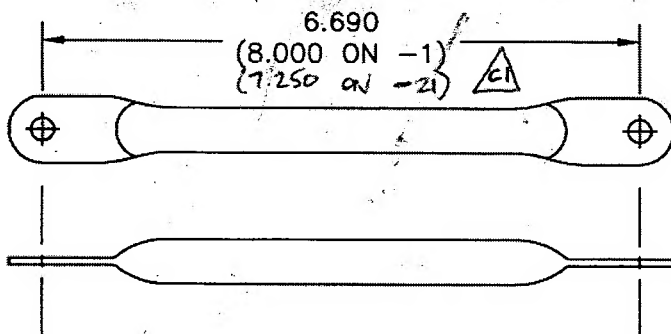
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE -041 PROP 6.69" LONG (END)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (END)
		ADD -045 PROP 7.25" LONG



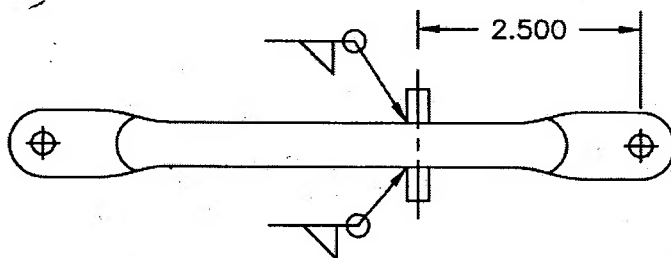
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5
D2332-3 SIMILAR - M/F D2332-1 & D2332-5
D2332-23 SIMILAR - M/F D2332-21 & D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

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03.07.04

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